Work Order ID 73786

Thursday, September 15, 2011 10:32:01 AM

Item ID: D2620
Revision ID:
Item Name: Skidtube, 206 Skidtube

Accept

Setup Start
Stop

Start Date: 9/15/2011 **Start Qty:** 10.00
Required Date: 10/28/2011 **Req'd Qty:** 10.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** W **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D2620	Rev B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Skidtubes	0.00							
Skidtubes	**Memo**	0.00							
Skidtubes	1-Bend extrusion as per Dwg D2620 usingCNC Bending Machine program 206.A □ and Folio Ft008□2- Cut Fwd end of tube as per Dwg D2620					DL/BE		11/09/19	
110	QC5- Inspect part completeness to step on W/O	0.00				DP		11-9-19	10
QC	**Memo**	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: 46	0.00				DP		11-9-19	10
Packaging	**Memo**	0.00							
Packaging									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 73786

Thursday, September 15, 2011 10:32:01 AM

Item ID: D2620 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Skidtube, 206 Skidtube

Start Date: 9/15/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 10/28/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

11/9/19

MF
11-09-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

Thursday, September 15, 2011 10:31:58 AM

Work Order ID: 73786

Parent Item: D2620

Parent Item Name: Skidtube, 206 Skidtube

Start Date: 9/15/2011 **Required Date:** 10/28/2011

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP D□02.07.26□Change Dwg to rev.B; Updated Location□RF□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-160		Manufactured	No			100	Each	93.0000	1	10			
Extrusion Round 3" 206													

Location	Loc Qty	Loc Code
LG	93	
43969	2	
59875	2	
68284	89	

10

02/DD 11-9-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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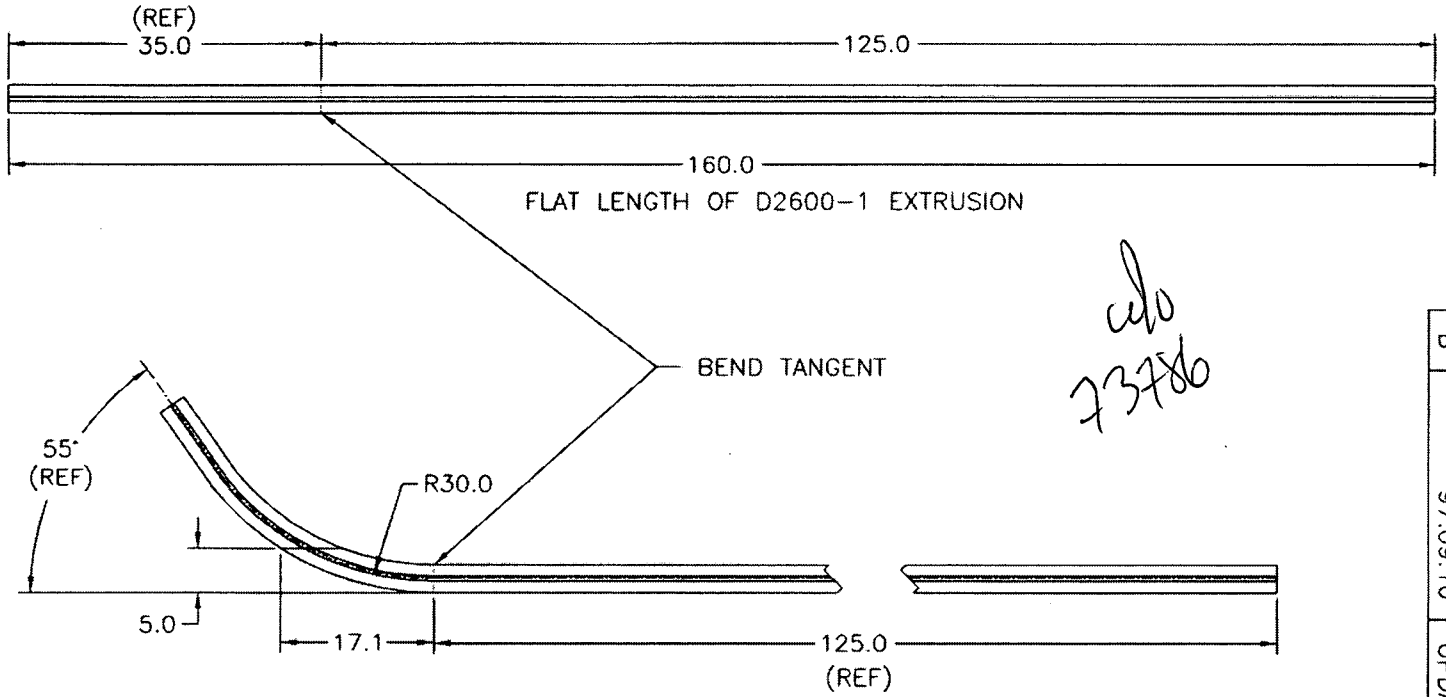
SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



c/o 73786

DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
   NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
   DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
   TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
   TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED
4-4-01 IS DS

REV	DATE	DESCRIPTION
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING

DESIGN | DRAWN BY RF | CHECKED | APPROVED | DATE 99.09.10

DART AEROSPACE USA, INC.
FAIRCHILD INTERNATIONAL AIRPORT, WA

DRAWING NO. D2620 | REV. B | SHEET 1 OF 1

TITLE 206 SKIDTUBE BENDING CONTROL | SCALE 1:20

QA COPY ISSUED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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